

Work Order ID 77113

77113

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November-25-11 1:38:59 PM

Item ID: D3911-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Eyebolt Receiver Assembly
 Start Date: 25/11/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 09/12/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 11/11/25 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3911	D								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	1- Assemble D3911-5 to D3911-3 and install rivet as per dwg Trim rivet to 1.250" Full Length								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

EP 11/12/06 (2)

EP 11/12/06 (2)

(+2)

8/12/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>ST 507</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

2x SP 11-12-07

11/12/18 J

MF 11-12-07

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Picklist Print

November-25-11 1:39:03 PM

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Work Order ID: 77113

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Parent Item: D3911-043

D3911-043

Parent Item Name: Aft Eyebolt Receiver Assembly

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP RevA: New issue DD verified by:EC

IPP REV:B

AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP REV :C As per

Rev C 10-04-07 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3911-3 *D3911-3* Aft Eyebolt Receiver		Manufactured	No			100	Each	12.0000	1	2			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST091		12							
				71151		12							
D3911-7 *D3911-7* Basket Plate-Eyebolt Receiver		Manufactured	No			100	Each	19.0000	2	4			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST091		19							
				68986		1							
				76012		10							
				76290		8							
MS20615-4M20 *MS20615-4M20* RIVET		Purchased	No			100	Each	214.0000	4	8			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		214							
				117071		30							
				118571		34							
				119546		50							
				119638		100							

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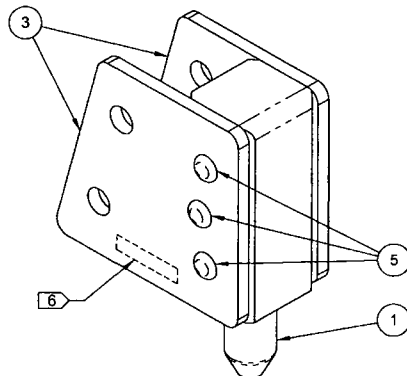
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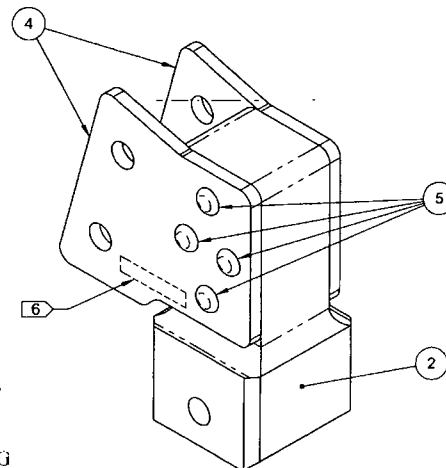
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3911-041	BASKET INSTL STUD ASSY (LOWER)
		X	D3911-043	AFT EYEBOLT RECEIVER ASSY
1	1		D3911-1	BASKET INSTL STUD (LOWER)
2		1	D3911-3	AFT EYEBOLT RECEIVER
3	2		D3911-5	BASKET STUD PLATE
4		2	D3911-7	BASKET PLATE-EYEBOLT RECEIVER
5	3	4	MS20615-4M20	RIVET



D3911-041 BASKET INSTL STUD ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3911-04X USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 0.63 lbs
-043: 0.99 lbs



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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT WRITE
WORK ORDER
NO 77113 M.C.J.
11/11/25

D3911-043 AFT EYEBOLT RECEIVER ASSY

RELEASED
2010-08-06

D	0.825 +0.000/-0.010 WAS 0.65 (B1-2)	MB	10.06.22
C	BOM: QTY (2): D4087-1 & MS21209-C610 REMOVED FROM -043 ASSY. WEIGHT UPDATED. D3911-3 REDESIGNED. D3911-043 & D3911-3 DETAIL UPDATED. MTL SPEC ADDED TO NOTES (SHT 2). DIM 0.375 WAS 0.400 (C3-3).	JPH	10.04.05
B	DIAMETER (B3-2) AND DIM ADDED (B2-2) & (C3-2)	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3911 REV. D SHEET 1 OF 3 TITLE AFT HARDPOINT, BASKET SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	JPH		
CHECKED	JPH		
MFG. APPR.	JPH		
APPROVED	JPH		
DE APPR.	JPH		
DATE	10.06.22		

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77113

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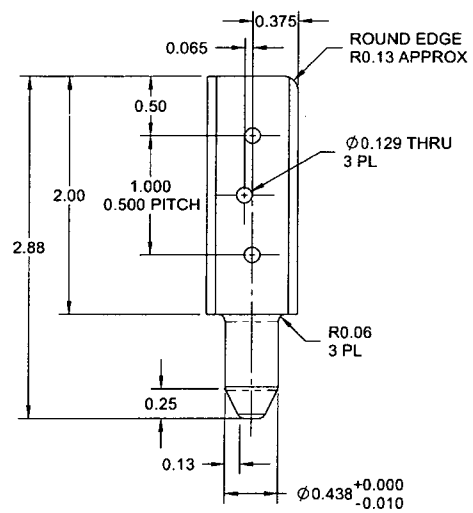
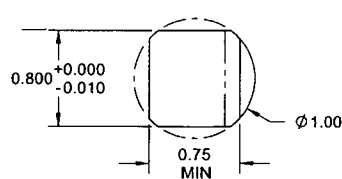
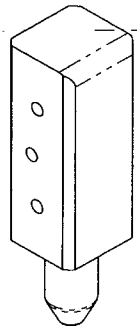
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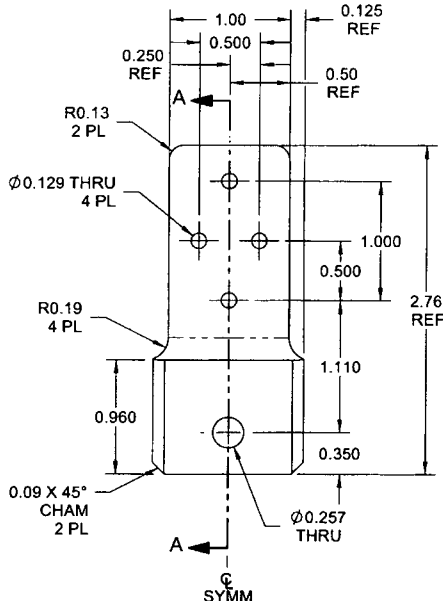
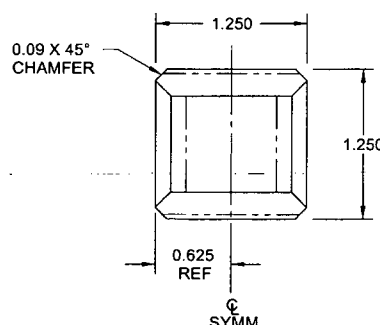
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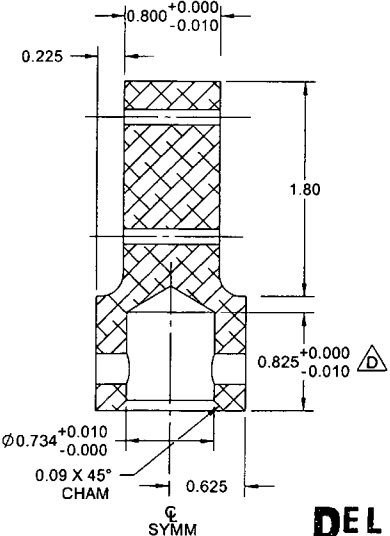
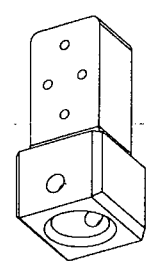
A



D3911-1 BASKET INSTL STUD (LOWER)



D3911-3 AFT EYEBOLT RECEIVER



SECTION A-A

RELEASED
2010-08-04
JMD

NOTES:

- 1) MATERIAL -1: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -1: 0.36 lbs
-3: 0.71 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. D
MFG. APPR.	JPH	D3911	SHEET 2 OF 3
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1

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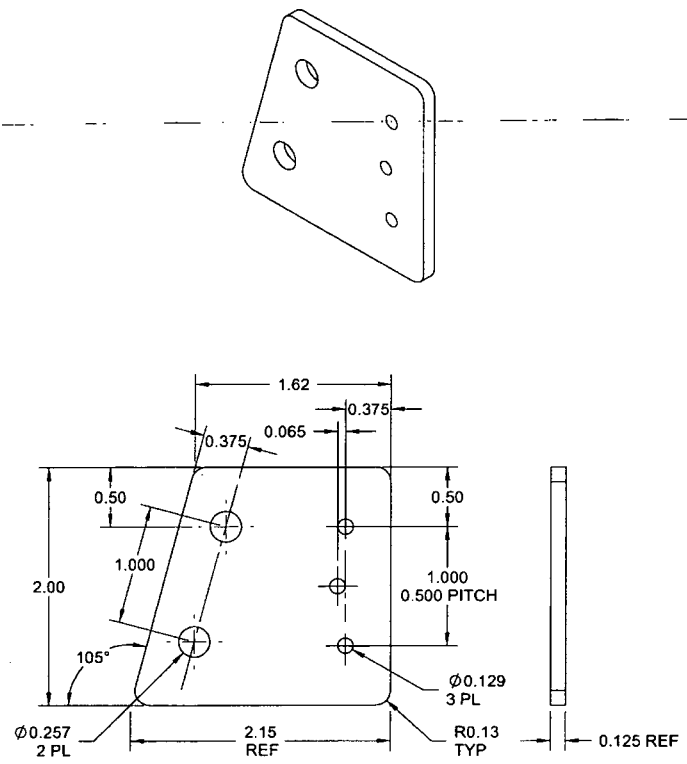
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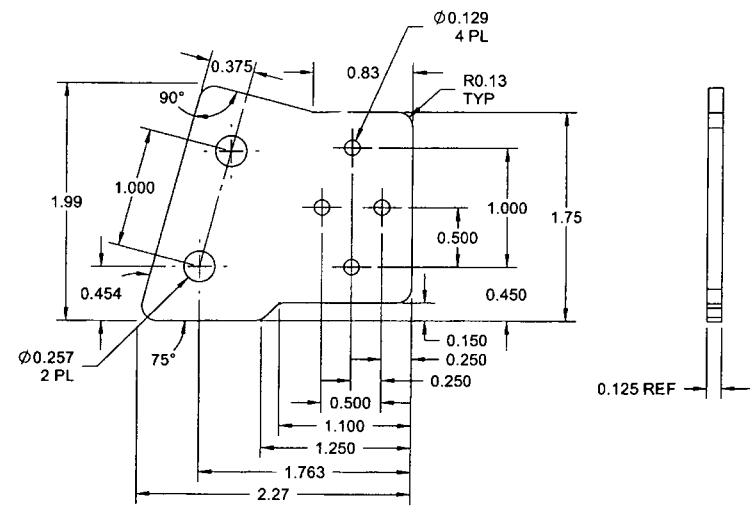
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D3911-5 BASKET STUD PLATE



D3911-7 BASKET PLATE-EYEBOLT RECEIVER

- NOTES:**
- 1) MATERIAL -5 & -7: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S11GA OR M303S11GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
 - 7) WEIGHT--5: 0.13 lbs
--7: 0.13 lbs

DESIGN	JPH	DART AEROSPACE LTD	
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CHECKED	9/10	DRAWING NO.	REV. D
MFG. APPR.	9/10	D3911	SHEET 3 OF 3
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RELEASED
2010-08-06
MD

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